Work Order ID 91219

91219

October-03-12 2:38:52 PM

Item ID: D2661-2 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 03/10/2012 **Start Qty:** 30.00 *30*
Required Date: 05/12/2012 **Req'd Qty:** 30.00 *30*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** MC5 **Date:** 12-10-03 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2661	**Revision Nbr** Rev E								
100		0.00							
100	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Program part number and batch number MACHINE AS PER DWG AND FOLIO FB071 FOLIO REV: E DWG REV: E		FK 12/11/20 PO 12/11/22			30	Ø		
110		0.00							
110	CONVENTIONAL MILLING MACHINE								
Mill Conv	**Memo**	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet		FK 12/11/20 PO 12/11/22			30	Ø		

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____
_____

Work Order ID 91219

91219

October-03-12 2:38:52 PM

Item ID: D2661-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 03/10/2012 **Start Qty:** 30.00 *30* **Cust Item ID:**

Required Date: 05/12/2012 **Req'd Qty:** 30.00 *30* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120			FK 12/11/20			30	Ø		
QC	Memo	0.00	PO 12/11/22						
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130			SJ 12/11/26			30	Ø		
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140						30	26	12-11-27	
HandFinish	Memo	0.00							
Hand Finishing									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

Work Order ID 91219

91219

October-03-12 2:38:52 PM

Item ID: D2661-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 03/10/2012 **Start Qty:** 30.00 *30*

Required Date: 05/12/2012 **Req'd Qty:** 30.00 *30*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				30X	0		MK 12/11/27
150 Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 11:10 OVEN TEMPERATURE: 320°F FINISH TIME: 11:40								
M123383									
160	QC3- Inspect Part Finish	0.00				30x	0		MK 11/27
160 QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: SK432	0.00				30			DAS 20 12/6/29
170 Packaging	**Memo**	0.00							
Packaging									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Work Order ID 91219

91219

October-03-12 2:38:52 PM

Item ID: D2661-2 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 03/10/2012 **Start Qty:** 30.00 *30*

Required Date: 05/12/2012 **Req'd Qty:** 30.00 *30*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180							12/12/39		
QC	**Memo**	0.00							
Quality Control									

CMF 12-11-30

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

Picklist Print

October-03-12 2:38:57 PM

Work Order ID: 91219 *91219*

Parent Item: D2661-2 *D2661-2*

Parent Item Name: Saddle, RH Fwd Aft Out 206

Start Date: 03/10/2012 **Required Date:** 05/12/2012

Start Qty: 30.00 **Required Qty:** 30.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	24.0000	1	30			
D6101-003									**				
Saddle Billet, 7075													

Location	Loc Qty	Loc Code			
MAT040	26		_____		
73775	2		_____		
73780	7		_____		
78599	10		_____		
80765	0		_____		
MAT042	-3		_____		
87498	4		_____		
MAT044	1		_____		
73769	1		_____		
92531			30	F.K.	12/11/16

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
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☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
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☐ Finish
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☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

DART AEROSPACE LTD	Work Order:	91219
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	3.611	3.621		3.6116	3.6116	3.6116	3.6116	3.6116
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.121	.118	.119	.118	.118
H	0.210	0.230		.223	.221	.222	.222	.222
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.490	2.490	2.490	2.491	2.491
K	1.313	1.343		1.325	1.324	1.324	1.324	1.323
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.137	1.1365	1.137	1.136	1.136
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.133	.133	.131	.131	.131
Q	0.240	0.260		.250	.249	.249	.250	.250
R	0.677	0.697		.687	.688	.688	.688	.6871
S	0.100	0.140		.127	.125	.125	.125	.125
T	1.565	1.585		1.577	1.577	1.577	1.576	1.576
U	0.540	0.560		.550	.549	.550	.550	.550
V	0.912	0.932		.923	.922	.922	.922	.922
W	0.787	0.807		.797	.797	.797	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.498	.500	.500	.498
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		.998	.999	.999	.999	.998
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.501	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.113	.112
			Accept/Reject	✓	✓	✓	✓	✓

Measured by:	FK	**Date:**	12/11/20
Audited by:	KJ	**Date:**	12/11/26
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD	Work Order:	91219
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
A	3.611	3.621		3.6166	3.6166	3.6166	3.6166	3.6166
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.120	.119	.122	.119	.118
H	0.210	0.230		.223	.222	.224	.222	.221
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.491	2.491	2.491	2.491	2.491
K	1.313	1.343		1.325	1.324	1.326	1.324	1.324
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.135	1.135	1.139	1.137	1.1355
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.131	.132	.131	.131	.131
Q	0.240	0.260		.250	.251	.247	.249	.249
R	0.677	0.697		.687	.687	.687	.687	.688
S	0.100	0.140		.126	.126	.126	.126	.126
T	1.565	1.585		1.575	1.576	1.579	1.577	1.576
U	0.540	0.560		.551	.550	.550	.550	.550
V	0.912	0.932		.922	.922	.922	.922	.922
W	0.787	0.807		.794	.797	.797	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.499	.500	.500	.500
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		.999	.999	.998	.998	.999
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.501	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.115	.112	.112
			Accept/Reject	✓	✓	✓	✓	✓

Measured by:	F.K.	**Date:**	12/11/21
Audited by:		**Date:**	12/11/26
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD	Work Order:	91219
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 **Rev: E** **DSK:** **Rev:**		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
A	3.611	3.621		3.6166	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.119	.120	.118	.118	.118
H	0.210	0.230		.222	.222	.220	.226	.226
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.491	2.491	2.491	2.491	2.491
K	1.313	1.343		1.325	1.325	1.327	1.325	1.325
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.136	1.137	1.132	1.134	1.135
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.124	.124	.127	.125	.126
Q	0.240	0.260		.247	.247	.249	.249	.251
R	0.677	0.697		.687	.689	.689	.686	.685
S	0.100	0.140		.120	.120	.122	.123	.123
T	1.565	1.585		1.5765	1.577	1.572	1.574	1.576
U	0.540	0.560		.547	.545	.545	.549	.548
V	0.912	0.932		.922	.922	.925	.927	.924
W	0.787	0.807		.797	.795	.795	.793	.794
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.499	.499	.500	.497	.500
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		.997	.996	.994	.997	.998
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.499	.498	.498	.499
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.236	.237
AG	0.510	0.515		.511	.511	.511	.511	.511
AH	0.100	0.120		.113	.113	.113	.113	.114
			Accept/Reject	✓	✓	✓	✓	✓

Measured by:	FK / PD	**Date:**	12/11/21
Audited by:		**Date:**	12/11/26
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD	Work Order:	91219
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 **Rev: E** **DSK:** **Rev:**		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	A 16	2 17	3 18	4 19	B 20
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.122	.118	.118	.116	.117
H	0.210	0.230		.221	.220	.222	.219	.221
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.491	2.491	2.491	2.491	2.491
K	1.313	1.343		1.325	1.325	1.325	1.325	1.323
L	0.178	0.198		.189	.188	.188	.189	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.139	1.135	1.135	1.133	1.132
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.125	.126	.127	.127	.126
Q	0.240	0.260		.247	.247	.246	.247	.246
R	0.677	0.697		.685	.689	.693 ~~.683~~	.690	.688
S	0.100	0.140		.121	.121	.121	.121	.121
T	1.565	1.585		1.579	1.575	1.576	1.573	1.572
U	0.540	0.560		.546	.546	.546	.545	.546
V	0.912	0.932		.922	.924	.923	.925	.925
W	0.787	0.807		.793	.795	.795	.796	.795
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	.5000	5.000	5.000
Z	0.490	0.510		.498	.498	.498	.497	.497
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		.999	.998	.998	.998	.999
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.499	.500	.499	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.236	.236
AG	0.510	0.515		.511	.511	.511	.511	.511
AH	0.100	0.120		.113	.113	.113	.113	.113
			Accept/Reject	✓	✓	✓	✓	✓

Measured by:	PD	**Date:**	12/11/26
Audited by:		**Date:**	12/11/26
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD	Work Order:	91219
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	25
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.115	.117	.117	.121	.119
H	0.210	0.230		.219	.221	.221	.223	.220
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.491	2.491	2.491	2.491	2.491
K	1.313	1.343		1.321	1.321	1.321	1.321	1.321
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.133	1.133	1.135	1.139	1.138
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.126	.128	.126	.126	.125
Q	0.240	0.260		.247	.248	.247	.246	.245
R	0.677	0.697		.689	.688	.686	.686	.685
S	0.100	0.140		.119	.123	.120	.120	.121
T	1.565	1.585		1.573	1.573	1.575	1.579	1.578
U	0.540	0.560		.546	.549	.548	.548	.547
V	0.912	0.932		.926	.927	.924	.924	.922
W	0.787	0.807		.797	.795	.795	.795	.795
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.497	.499	.498	.498	.499
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		.999	.998	.998	.997	.998
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.236	.236
AG	0.510	0.515		.511	.511	.511	.511	.511
AH	0.100	0.120		.113	.113	.113	.113	.113
			Accept/Reject	✓	✓	✓	✓	✓

Measured by:	PD	**Date:**	12/11/23
Audited by:	SJ	**Date:**	12/11/26
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD	Work Order:	91219
Description: 206 Saddle, Outboard, Right side	Part Number:	D2661-2
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				26 (1)	27 (2)	28 (3)	29 (4)	30 (5)
A	3.611	3.621		3.616	3.616	3.6166	3.6166	3.6166
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.118	.117	.119	.118	.118
H	0.210	0.230		.220	.221	.221	.221	.222
I	0.615	0.685		.680	.680	.6800	.6800	.6800
J	2.470	2.510		2.491	2.491	2.491	2.491	2.491
K	1.313	1.343		1.321	1.321	1.324	1.323	1.323
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.134	1.136	1.137	1.132	1.135
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.127	.127	.127	.127	.128
Q	0.240	0.260		.247	.246	.248	.250	.249
R	0.677	0.697		.689	.689	.687	.688	.687
S	0.100	0.140		.121	.122	.122	.124	.122
T	1.565	1.585		1.574	1.576	1.577	1.575	1.576
U	0.540	0.560		.547	.546	.550	.550	.550
V	0.912	0.932		.926	.928	.923	.922	.923
W	0.787	0.807		.795	.797	.796	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.499	.502	.500	.500
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		.999	.998	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.499	.499	.500	.500	.502
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.236	.236
AG	0.510	0.515		.511	.511	.512	.512	.512
AH	0.100	0.120		.113	.113	.112	.112	.112
			Accept/Reject	✓	✓	✓	✓	✓

Measured by:	PD / FK 12/11/24	**Date:**	12/11/23
Audited by:		**Date:**	12/11/26
Prototype Approval:		**Date:**	

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

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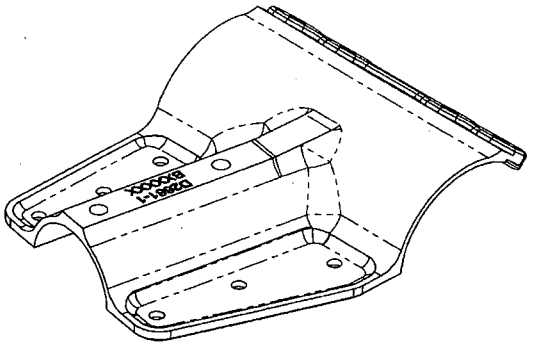
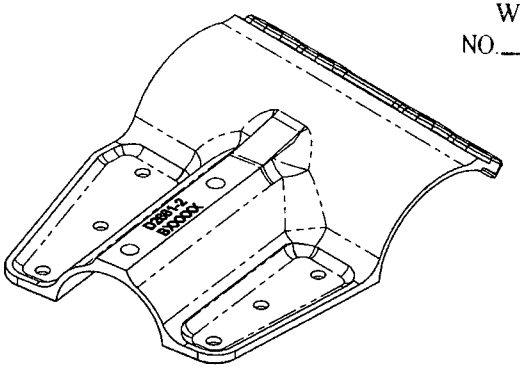
WORK ORDER
NO. 91219 MW

12-10-03



D2661-1 SADDLE, OUTSIDE, LH



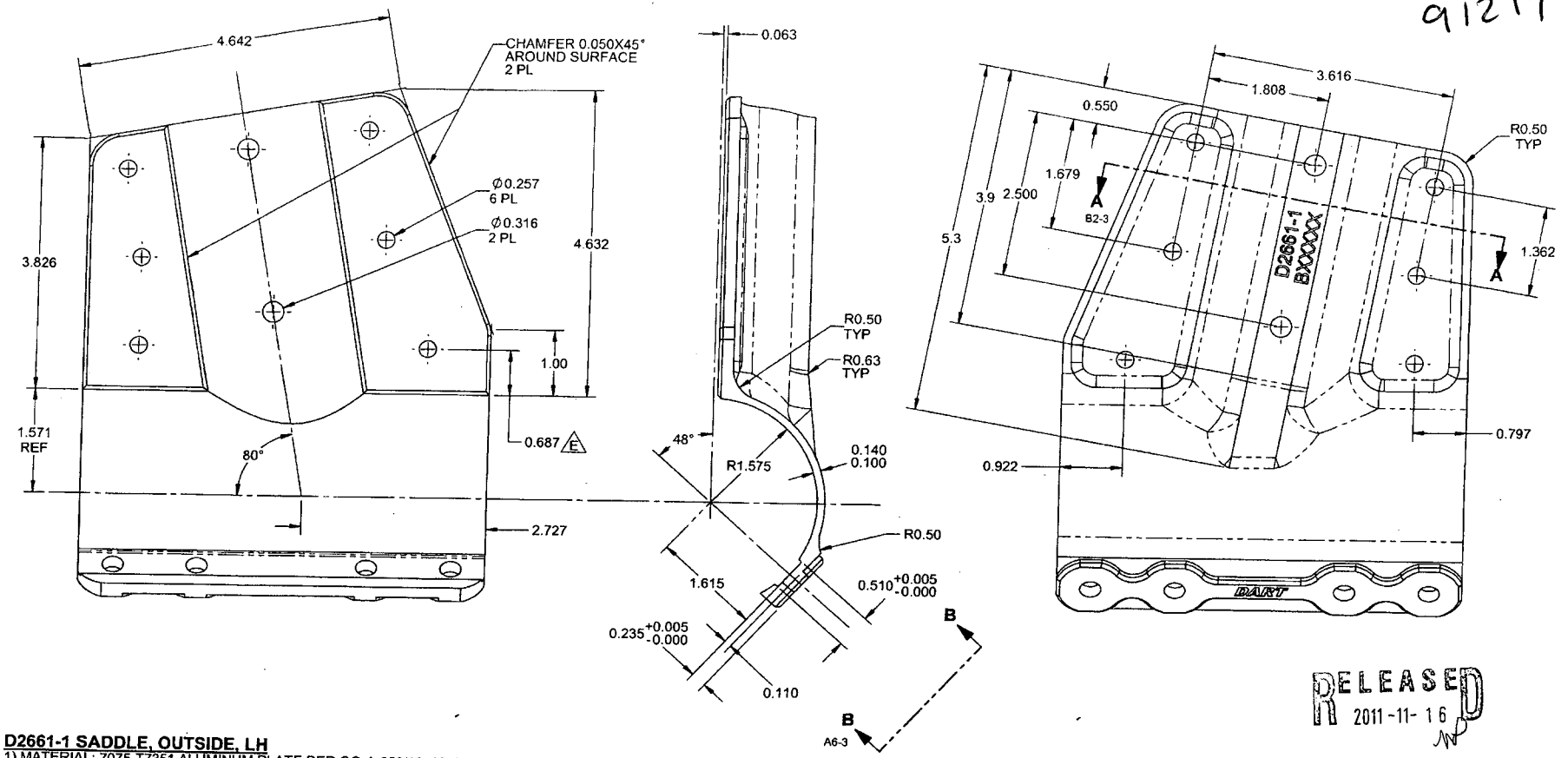
D2661-2 SADDLE, OUTSIDE, RH

RELEASED
2011-11-16

REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4). REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25

DESIGN		DART AEROSPACE USA, INC. KENT, WA	
DRAWN			
CHECKED		DRAWING NO. D2661	REV. E
MFG. APPR.			SHEET 1 OF 5
APPROVED		TITLE SADDLE, OUTSIDE	SCALE NTS
DE APPR.			
DATE	11.10.31		

91219



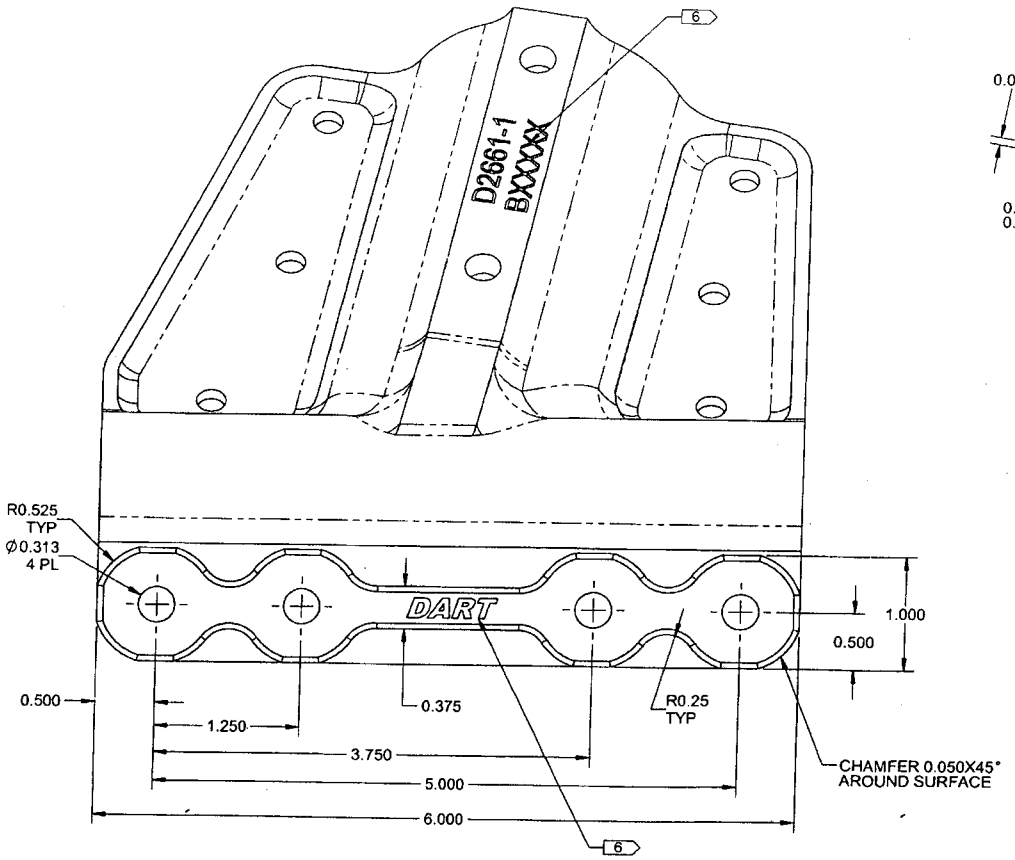
RELEASED
2011-11-16
JN

D2661-1 SADDLE, OUTSIDE, LH

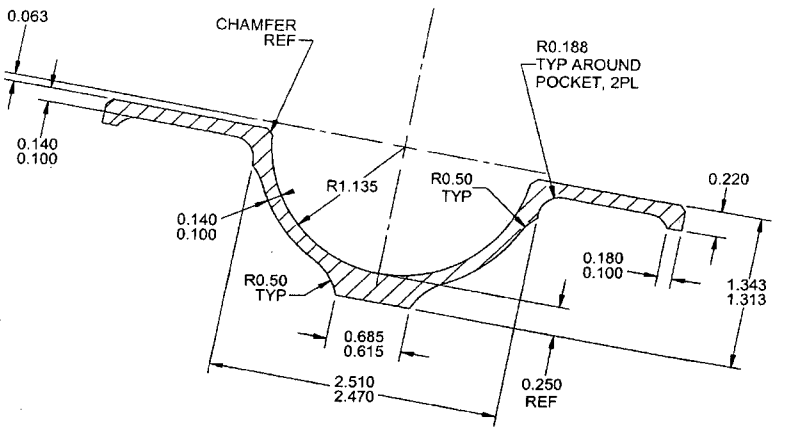
1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		DRAWING NO. D2661 REV. E
CHECKED	ASS	SHEET 2 OF 5
MFG. APPR.		TITLE SADDLE, OUTSIDE SCALE NTS
APPROVED		
DE APPR.		
DATE 11.10.31		

91219



VIEW B-B A4-2
SCALE 1.5X
VIEW ROTATED

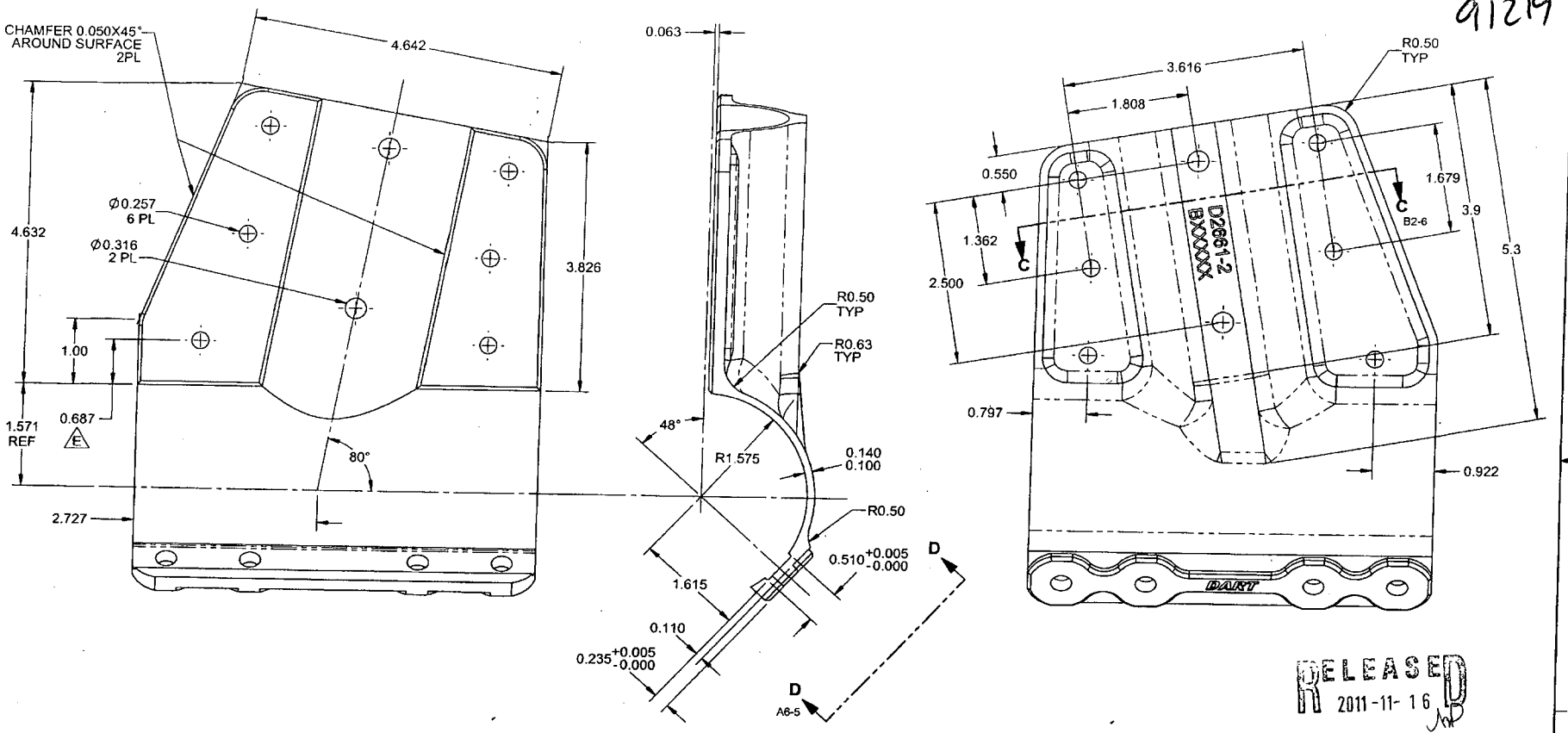


VIEW A-A C3-2
SCALE 1.5X

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2661 REV. E
MFG. APPR.		SHEET 3 OF 5
APPROVED		TITLE SADDLE, OUTSIDE SCALE NTS
DE APPR.		
DATE 11.10.31		

91219



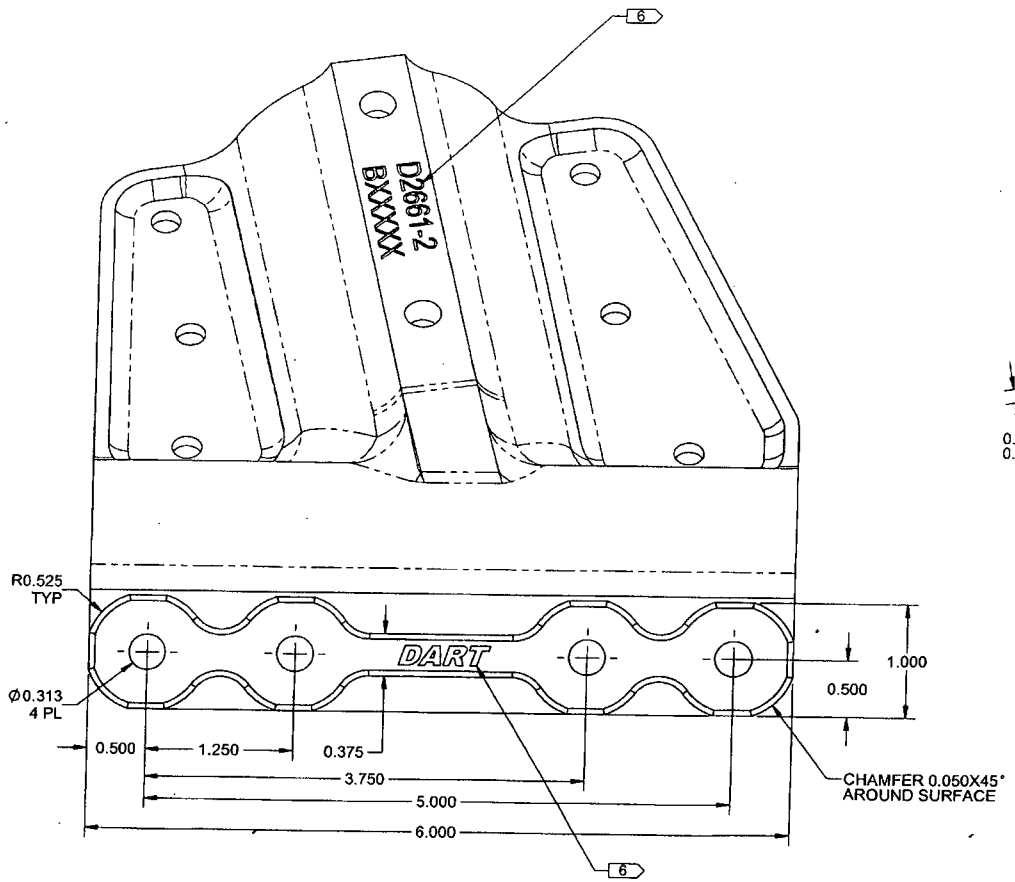
RELEASED
2011-11-16

D2661-2 SADDLE, OUTSIDE, RH

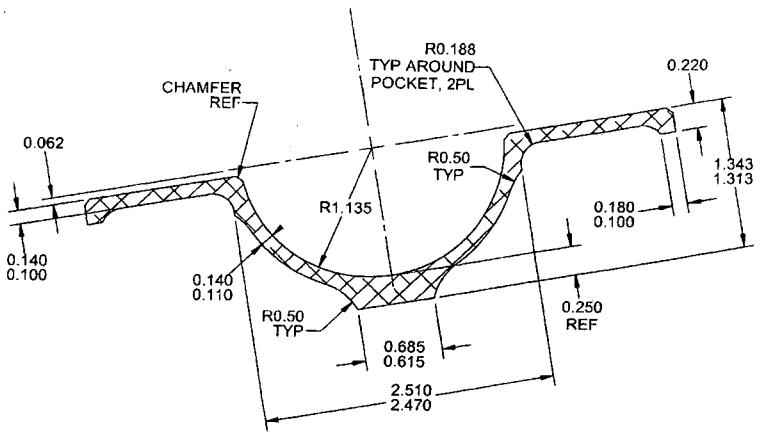
1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED	ASS	DRAWING NO. D2661 REV. E
MFG. APPR.		SHEET 4 OF 5
APPROVED		TITLE SADDLE, OUTSIDE SCALE NTS
DE APPR.		
DATE 11.10.31		

G1219



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

RELEASED
2011-11-16

DESIGN		**DART AEROSPACE USA, INC.** KENT, WA
DRAWN		
CHECKED		DRAWING NO. D2661 — REV. E — SHEET 5 OF 5
MFG. APPR.		TITLE SADDLE, OUTSIDE — SCALE NTS
APPROVED		
DE APPR.		
DATE 11.10.31		